

Date: Wednesday, 7/4/2007 3:59:36 PM  
 User: Eric Charbonneau

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GPS RECEIVER HOUSING
Job Number	: 33306		
Estimate Number	: 12493		
P.O. Number	: N/A	Part Number	: D35145
This Issue	: 7/4/2007 S.O. No. : N/A	Drawing Number	: UNDER REVIEW
Prsht Rev.	: NG	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: N/A
Previous Run	: 28357	Material	: N/A
Written By	: <u>Id/07-07-12</u>	Due Date	: 7/11/2007
Checked & Approved By	:	Qty:	1 Um: Each
Comment	: Est Rev:A New Issue 06-07-26 JLM		

# PROTOTYPE

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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IB 07-07-06



Comment: Qty.: 0.2518 sf(s)/Unit Total: 0.2518 sf(s)

6061-T6 .040 Sheet

(M6061T6S040)

Batch: M103321

m100742

CERTIFICATE OF CONFORMITY  
REQUIRED

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3514

Dwg Rev: PREL

Prog Rev: PREL

\*\*\*Ensure Grain Direction is correct\*\*\*\*\*

2-Deburr if necessary

IB 07-07-06

MF 07-07-09

PTD  
Last page →

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 07-07-06



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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ES



Comment: SECOND CHECK

07/07/10

(41)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Form as per Dwg D3514

IB 07 107/10 (1)

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 33306

Part Number: D35145

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Countersink as per Dwg D3514

*mf 07-07-10*

7.0

QC5

*FAI NEEDS MORE SLOTS*

INSPECT WORK TO CURRENT STEP



*CB 07.07.11*

**ENGINEERING  
APPROVAL**



*Jul 07.07.10*

Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*N/A 3*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

**FOR ENGINEERING USE ONLY**

*EC 07.07.19*

11.0

QC21

FINAL INSPECTION/W/O RELEASE



*07.07.19*

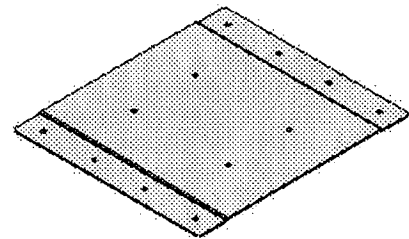
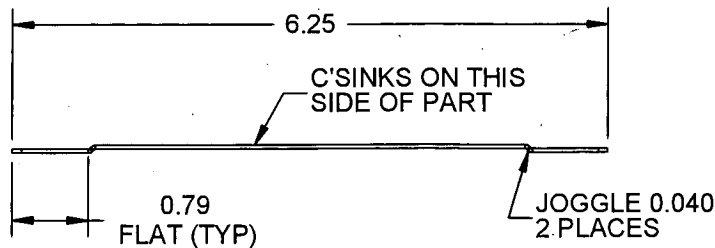
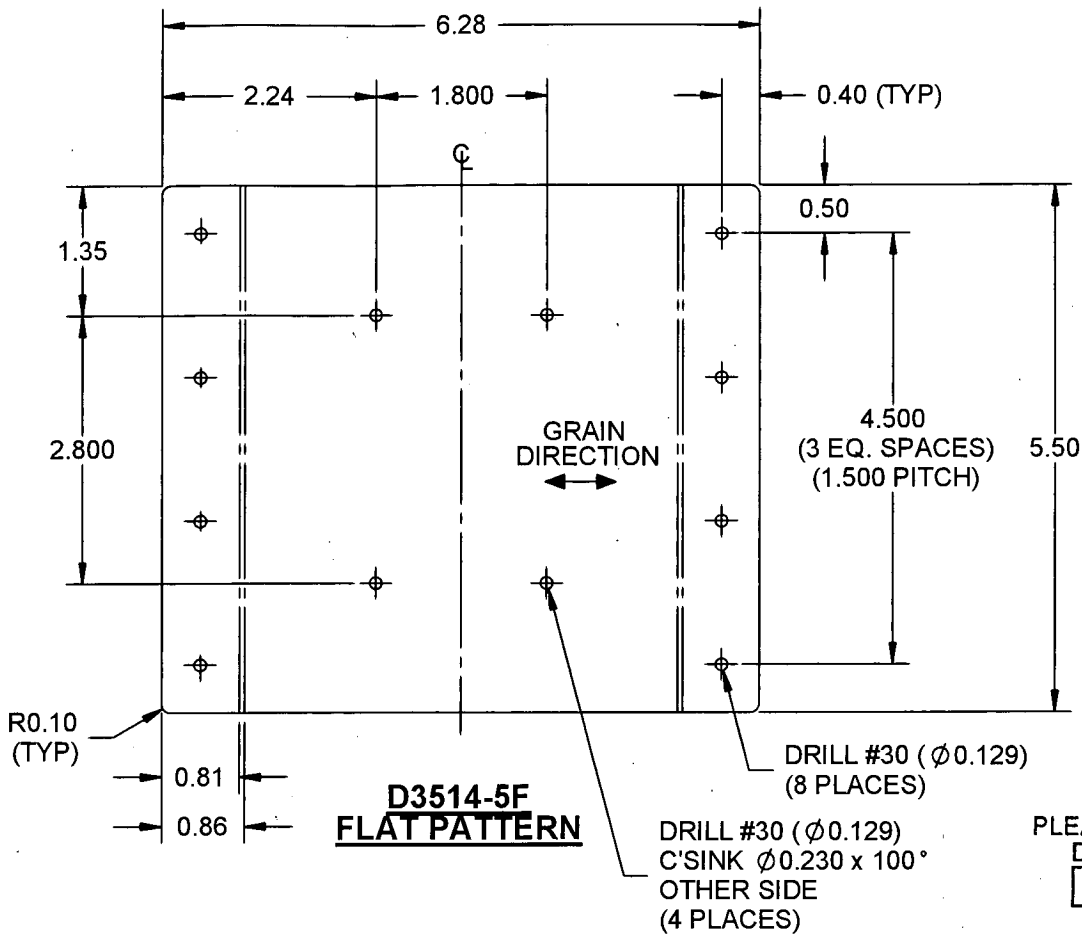
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*Jul 07.07.10*

DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED	DRAWING NO. <b>D3514</b>	REV. A
DATE <b>07.06.18</b>	TITLE <b>GPS RECEIVER HOUSING</b>		SHEET 7 OF 9 SCALE 1:2



**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C
- 7) C'SINK ABOVE JOGGLE


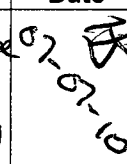
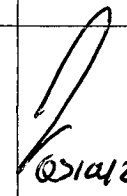
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3514-5 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>33306</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/09	2.0	1 part scrap <del>wrong</del> mat. used. on water test  R.C. Human Error	 QS/14/2	Scrap/destroy and replace Remind employee to be more cautious when pulling and results not. Batch: <del>10107722</del> M100742	07-07-10 	EN 07/07/10	 QS/14/2	cr 07/07/09

NOTE: Date & initial all entries



# Receiving Report

Date: April 21/06  
 Supplier: Copper & Brass

Batch No: 51100742  
 Dart P/O: 1005

Packing Slip: Yes ☒ No ☐  
 Invoice: Yes ☐ No ☒  
 Receipt: Cash ☐ Cr. ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐  
 Waybill Attached: Yes ☐ No ☐  
 Shipment Complete: Yes ☐ No ☒  
 Q.C. Inspection ☐

Discrepancies						Comments
Part No.	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	
MS0524325090	Sheet	96	0	0	96	
M6061T6B250X06000		48	0	0	48	
M6061T6B0500X0250		12	10	0	2	

ISR No: \_\_\_\_\_

Initials of receiver (if shipment OK) [Signature]

Production/Admin:

Date:

06/04/25  
PCP1298

Received/Costing:

Initial:

113009000/Forms/Purchase/RECREPORT rev B

Accounting:

Date:

AP/MR:

Initial:

DESCRIPTION OF MATERIAL	BILLING QTY	UNIT	PRICE	EXTENSION
RECT 6061-T6511 EXTR ALUMINUM BAR 019884 3/8 (+/- .008) X 1 (+/- .0 UZ3803 NO PROCESSING - 144" ML	1.00	PC	138.0700	138.07
GST/HST				9.66
PLEASE REMIT IN CANADIAN FUNDS				


INVOICE WILL BE DATED THE DAY OF SHIPMENT. INTEREST WILL BE CHARGED ON PAST DUE ACCOUNTS AT THE RATE OF 1-1/2% PER MONTH  
 PRICE SHOWN IS SUBJECT TO PRICE IN EFFECT AT THE TIME OF SHIPMENT.

G.S.T. REG. NO. 14022393

TOTAL \$ 147.73

REMIT BY: 05/15/06

TERMS: NET 30 DAYS

90294	SHIP DATE 04/24/06 SHP	GROSS WEIGHT	QUOTE 30-161074-1	0 OF 10 TEST RESULTS	
ART AEROSPACE		WORK ORDER **	ORDER DATE 04/13/06 ORD		
SHIP TO ART AEROSPACE 270 ABERDEEN ST AWKESBURY ON CANADA K6A 1K7		DELIVERY DATE 04/24/06 DEL	SHIP BRANCH 30(04)	SELL BRANCH 30-TOR	WORK ORDER UZ3809
6905 KENDERRY GATE, MISSISSAUGA ONTARIO, CANADA L5T 2Y		<b>Copper and Brass Sales Canada</b>  A ThyssenKrupp Materials NA company <b>ThyssenKrupp</b>			
ORDER NUMBER 000001005	TERRITORY 01	ENTRY ID 30BXT	CUSTOMER SIGNATURE		
INSIDE SALES BRIAN TEDESCO		QUANTITY		ORDERED	SHIPPED
INSIDE SALES TELEPHONE (905) 632-9577		INVENTORY		54.19 LB	52.00
SHIP VIA		BILLING		2.00 PC	2.00
COMPLETE X		PARTIAL		WAREHOUSE	
CANCELED		PACKED WITH OTHER GOODS		UZ3800	
CUSTOMER COMMON/FRT-CCX		FINISHED GOODS LOCATION		WARN LABEL:1001	
PPD		063496-4			

**PART DESCRIPTION**

061-T6 FLAT ALUMINUM SHEET, .040 X 48 X 144  
 DART AEROSPACE, NO PROCESSING - 48" X 144" Mill  
 imensions., Test Results Attn to: QA Department.  
 HEET MUST BE PACKAGED WELL TO PROTECT , FROM DAMAGE IN TRANSIT. CUSTOMER WILL  
 EFUSE DELIVERY IF DAMAGED. MILL TEST , REPORTS MUST ACCOMPANY ALL SHIPMENTS

**SPECIAL INSTRUCTIONS**

Shipping, do not place any packages or goods on top of our material."

SCRAP	FILLED BY SC	PACKED BY	Q/A AUDIT
RECEIVED HOURS 8-3	MAX SKID WEIGHT 100	LOADING INSTRUCTIONS HAND, CRANE, FORK, DOCK	MAXIMUM BUNDLE WEIGHT 200
BAR	CASES	CUSHIP	PKGS
INSPECTION RECORD	SKIDS	BDLS	TUBES
	CTNS	FLAT	COILS

**TEST RESULTS**

DECLARATION OF COMPLIANCE  
 We hereby certify that mercury or any of its compounds are not used in the processing and distribution of our products.  
 products we distribute are not hazardous in their received state. For MSDS sheets go to [www.copperandbrass.com/msds](http://www.copperandbrass.com/msds)  
 244-234-5682. We hereby certify that the material above complies with the following specifications:  
 AMS 4027      ASTM-B209  
 ROHS COMPLIANT

QUANTITY	UOM	VENDOR	VEND PO	HEAT/LOT	PCS	TAG NO	QUANTITY	UOM	VENDOR	VEND PO	HEAT/LOT	PCS
52.00	LB	CORUS	0001837	7124901								